

5/20

DART AEROSPACE LTD	Work Order:	22960
Description: End Plate	Part Number:	D3067-1
Drawing: D3067 Rev. A	Qty:	160 158
		Page 1 of 1

RF 02/10/17

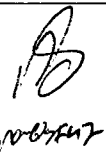

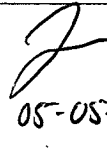
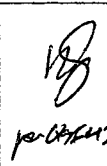
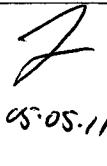
Stack of 8

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	RF	05.04.13	160
2	MV	Cut blanks 2.750" x 3.030" +/- 0.005 Grain along 2.750" Material: 5052-H32 (QQ-A-250/8) (M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063) ^{M15120} Batch: ^{M15628} ^{M13886} ^{M14890}	RF	05/03/20	160
3	MV	Machine per folio FA183 and Dwg D3067	RF	05/04/22	160
4	QC2	Inspect parts as they come off the CNC machine	RF	05/04/22	160
5	QC7	Second inspection	RF	05/04/22	160
6	MV	Deburr	RF	05/05/10	160
7	GB	Bend as per Dwg D3067	RF	05-05-11	158 PTO
8	QC5	Inspect work to Step 7	RF	05-05-11	158
9	WA	Identify and stock	RF	05-05-11	158
10	AC	Cost / Part 1.55	RF	05-05-12	158
11	DC	Close W/O 1.45 Inspect level 21	RF	05.05.17	158

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	EC	
B	02.01.03	Now machined on HAAS	SM	
C	02.10.04	Re-format	KJ, RF	
C1	03.01.21	Remove step 6 (Deburr)	RF	

RELEASED
02/10/15 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-11	7	2 parts scrap. stopped for bad bends. operator error		Scrap: destroy	 05-05-11	 05-05-11	 05-05-11	 05-05-11

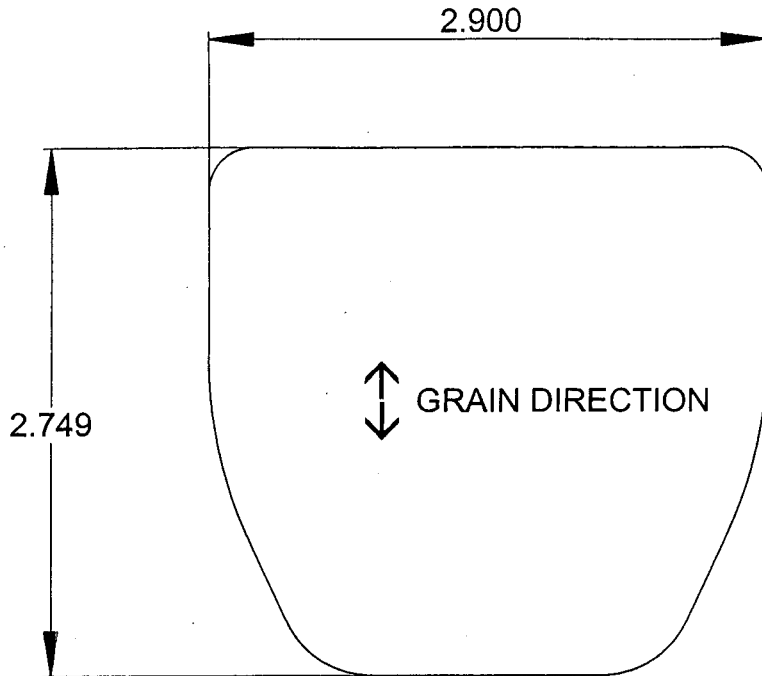
Part No: D3067-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 29 Date: 05/05/17

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

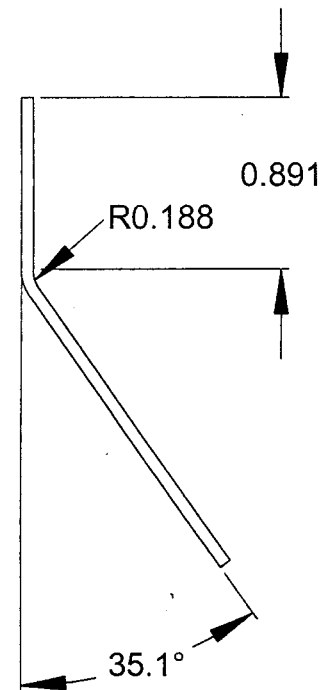


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO REWORK
FROM NOTICE
WORK ORDER
NO. 22960

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT ©2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 11, 2005
07:31 am

Work Order No : 0022960
Project Name : D3067-1
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3067-1
Description : End Plate
Manufactured : Yes
Amount Req'd : 160
Amount Done : 0
Start Date : 04-08-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00